

Date: Thursday, 10/18/2007 8:03:05 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	RADIUS BLOCK	
Job Number	35205				
Estimate Number	10822				
P.O. Number	N/A		Part Number	D2274	
This Issue	10/18/2007	S.O. No.	Drawing Number	D2274 REV F	
Prsh Rev.	NC		Project Number	N/A	
First Issue	N/A	Type	Drawing Revision	F	
Previous Run	32857		Material	N/A	
Written By			Due Date	11/10/2007	
Checked & Approved By	<i>JL 07.10.18</i>		Qty:	500	Um: Each
Comment	Est. H 00.05.18 Added inspection level 8 EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0750X00125	6061-T6 Bar .75" x .125"	
		Comment: Qty.: 0.0962 f(s)/Unit Total : 48.0900 f(s) 6061-T6 Bar .75" x .125"	
		Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch <i>W105061 JL 07/10/21</i>	
2.0	SHEAR	SHEAR	
		Comment: SHEAR Shear blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces	<i>JL 07/11/21</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2274	<i>DSR 07/12/08</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	<i>530</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>DSR 07/12/08</i>
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>TG 07.12.10 530</i>
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble Deburr any rough edges after tumbling	<i>DSR 07/12/08 530</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/21/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: RADIUS BLOCK

Job Number: 35205

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Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005.4.1

YL

07-12-11

530X

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/12/11 53C

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST24

LC 7/12/12 530

53G

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

FL 07/12/13

Job Completion



min restock

CY

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35205
Description: Radius Block	Part Number:	D2274
Inspection Dwg: D2274 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	DSP	Audited by:	<u>Onf</u>	Prototype Approval:	
Date:	07/12/08	Date:	07/12/08	Date:	

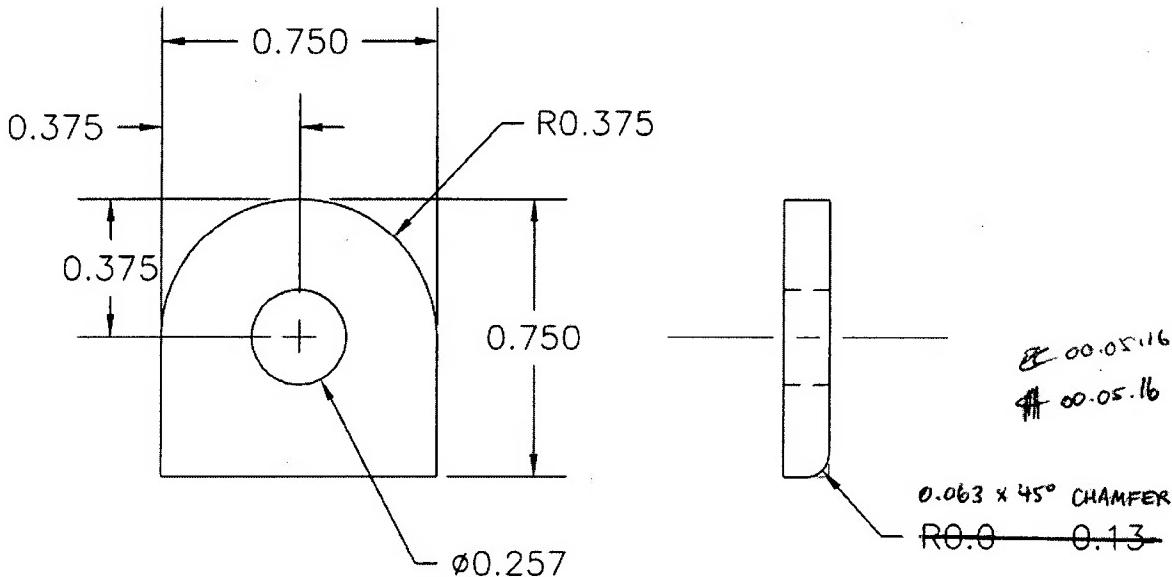
Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	



DO COPY
LSD
DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MJ</i>	APPROVED <i>CS</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11	TITLE RADIUS BLOCK		SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/18 KE



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35205